

Date: Tuesday, 10/23/2007 3:11:19 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 35330	
Estimate Number : 10980	
P.O. Number : N/A	Part Number : D2808
This Issue : 10/23/2007 S.O. No. : N/A	Drawing Number : D2808 UNDER REVIEW OK SEE
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A1
Previous Run : 34034	Material : N/A
Written By : _____	Due Date : 11/2/2007
Checked & Approved By : <u>10.23</u>	Qty: 100 Um: Each
Comment : Est Rev:D 02.03.07 Now turned in house NG	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6R0625

6061-T6 Round Bar .625"



Comment: Qty.: 0.0557 f(s)/Unit Total : 5.5650 f(s)

6.3'

6061-T6 Round Bar .625"

(M6061T6R0625)

Batch: 1010610420 07/11/08-09

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA205(Mesure D3387 Bracket .507" Dia for Proper press-fit)

2-Deburr

20 07/11/08-09

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 07/11/08-09

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

25 07/11/08 (102)

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS 07-11-12

(K102)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 07/11/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/23/2007 3:11:19 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 35330

Part Number: D2808

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*AS 7/4/12 102*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*8148*

*AS 07/11/12 AS 102*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*102*  
*AS 07/11/13*

Job Completion



*U 07.11.12*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2808	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	<i>CP</i> 01.04.26	ADD POWDER COAT ; $\phi 0.500$ WAS $\phi 0.507$	

RELEASED  
00.11.13 *[Signature]*

UNDER REVIEW

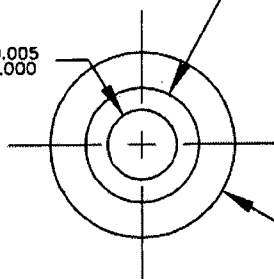
07.10.22 DC

OR PER HAND  
CHANGES

07.10.23 DC

$\phi 0.313^{+0.005}_{-0.000}$  C'BORE 0.359 DEEP

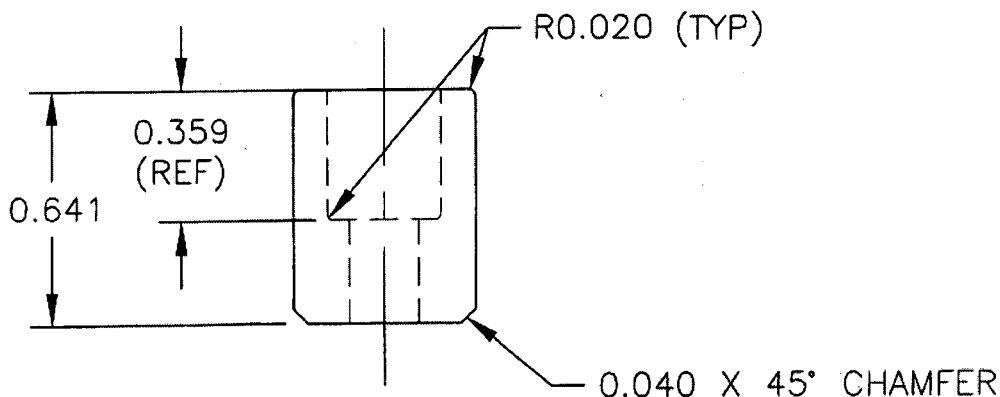
$\phi 0.191^{+0.005}_{-0.000}$



$\phi 0.507^{+0.001}_{-0.000}$

07.10.23 DC

~~$\phi 0.507^{+0.001}_{-0.000}$~~   ~~$\phi 0.500^{+0.001}_{-0.000}$~~



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020  
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

DO NOT  
POWDER COAT  
UNTIL AFTER  
PRESS FIT

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7)  
OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

07.10.23 DC

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35330

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